

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	:	35933			
Estimate Number	:	10533			
P.O. Number	:	N/A	Part Number	:	D2573
This Issue	:	11/21/2007	S.O. No.	:	N/A
Prsht Rev.	:	NC	Drawing Number	:	D2573 REV E
First Issue	:	N/A	Project Number	:	N/A
Previous Run	:	35917	Drawing Revision	:	E
Written By	:	<u>[Signature]</u>	Material	:	N/A
Checked & Approved By	:	<u>[Signature]</u>	Due Date	:	12/23/2007
Comment	:	Est: 1 As Per RevE 06-01-27 JLM	Qty:	:	12 Um: Each

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10	D6101007	7075-T7351 8.25X7.75X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit      Total : 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: **B 31389**

ML 07/12/27

20	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program Batch No. 35933 Double check by: DSP

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

#### 4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

ml/ S.F 07/12/21

47

42

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

19ml 07/12/27

11



4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

07/12/27

11

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 08/01/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 35933

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/01/04

(11)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-h

08/01/07

(11X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 106379

BL 08-01-07

(11)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-h

08/01/07

(11X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

LS 08/01/07 (11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208101/08

(11)

Job Completion



mi 2008/1/8

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	35933
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.440	.440	0.440		
B	1.745	1.755		1.747	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.002		
F	0.490	0.510		.500	.502	.501	0.502		
G	0.257	0.262	<del>DT8683</del>	.258	.258	.258	.258		
H	0.375	0.380	<del>DT8684</del>	.375	.375	.375	.375		
I	0.490	0.510		.502	.502	.504	.504		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.124	.124	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	.250		
S	0.115	0.135		.115	.126	.126	.121		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.233	3.233		
V	0.230	0.250		.230	.240	.242	.238		
W	0.115	0.135		.125	.134	.125	.125		
X	0.308	0.313		.310	.310	.310	0.310		
Y	0.760	0.765		.750	.750	.760	0.764		
Z	0.352	0.372		.370	.370	.370	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	0.630		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.500		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.240	.240	.242	.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.F. / J.F.
Date:	07/12/20 07/12/24

Audited by:	S.A.
Date:	08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	35933
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	D2573
<b>Inspection Dwg:</b> D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.438	0.443	<del>DT8682</del>	0.440	0.440	0.440	0.440		
B	1.745	1.755	<del>DT8683</del>	1.750	1.750	1.750	1.750		
C	3.495	3.505	<del>DT8684</del>	3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.002		
F	0.490	0.510		0.501	0.502	0.501	0.502		
G	0.257	0.262	<del>DT8683</del>	0.258	0.259	0.259	0.258		
H	0.375	0.380	<del>DT8684</del>	0.375	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.502	0.501	0.502		
J	1.174	1.184		1.180	1.178	1.178	1.178		
K	0.558	0.578		0.568	0.567	0.568	0.570		
L	1.174	1.184		1.180	1.178	1.178	1.178		
M	1.365	1.375		1.375	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	4.119	4.129		4.124	4.121	4.122	4.123		
P	0.115	0.135		0.124	0.126	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.249	0.249	0.250		
S	0.115	0.135		0.125	0.121	0.121	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.233	3.230	3.236	3.230		
V	0.230	0.250		0.240	0.239	0.237	0.237		
W	0.115	0.135		0.125	0.123	0.123	0.120		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.760	0.760	0.761		
Z	0.352	0.372		0.364	0.364	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.631	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.248	0.245	0.245		
AE	1.500	1.520		1.510	1.510	1.513	1.515		
AF	0.115	0.135		0.125	0.135	0.125	0.126		
AG	0.240	0.280		0.265	0.265	0.260	0.260		
AH	0.240	0.260		0.250	0.248	0.247	0.248		
AI	2.000	2.020		2.000	2.002	2.002	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SR
Date:	02/12/21 / 07/12/27

Audited by:	SA
Date:	03/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>35933</b>
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	<b>D2573</b>
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

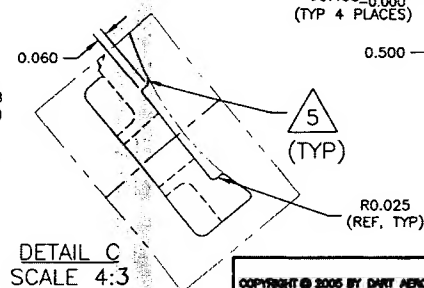
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	210	311	412		
A	0.438	0.443	<del>DT8682</del>	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.250	1.250	1.250	1.250		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.500	0.502	0.503	0.504		
G	0.257	0.262	<del>DT8683</del>	0.259	0.259	0.259	0.259		
H	0.375	0.380	<del>DT8684</del>	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.502	0.502	0.503		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.569	0.569	0.569	0.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.499	2.500	2.500		
O	4.119	4.129		4.122	4.122	4.122	4.122		
P	0.115	0.135		0.126	0.126	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.249	0.249		
S	0.115	0.135		0.120	0.119	0.120	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.236	3.230		
V	0.230	0.250		0.239	0.238	0.237	0.237		
W	0.115	0.135		0.120	0.119	0.121	0.121		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.762	0.760		
Z	0.352	0.372		0.362	0.364	0.362	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.632	0.632	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.245	0.247	0.247		
AE	1.500	1.520		1.512	1.512	1.512	1.513		
AF	0.115	0.135		0.126	0.126	0.126	0.126		
AG	0.240	0.280		0.260	0.260	0.260	0.266		
AH	0.240	0.260		0.247	0.247	0.247	0.247		
AI	2.000	2.020		2.002	2.002	2.002	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>ML</i>
Date:	07/12/27







Audited by:	<i>SL</i>
Date:	08/01/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>




05.12.06



MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |   |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)   |
|  | CHAMFER 0.063" x 45° ALL AROUND   |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

Technical drawing of a mechanical part, showing a cross-section with dimensions and features. The drawing includes a central section labeled "VIEW B-B" and a "DART" feature. Dimensions are provided for various sections: 1.73, 0.20, 1.75 ± 0.005, 3.500 ± 0.005, and 8.000. Surface finish requirements are indicated by "R0.66 (TYP)" and "R0.50 (TYP)". A feature is labeled "2" with a triangle symbol.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		DRAWN BY
DS		PH
CHECKED 		APPROVED 
		
		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DATE		DRAWING NO.
05.07.13		D2573
		TITLE
		OUTER AFT SADDLE
		REV. 1 OF 2
		SCALE
		2:

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN	DRAWN BY		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
DS	PH		
CHECKED 	APPROVED 	DRAWING NO. D2573	REV. _____ SHEET 1 OF _____
DATE 05.07.13		TITLE OUTER AFT SADDLE	SCALE 2:1

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NO. 25933